

Work Order ID 76785

76785

Page 1

November-21-11 11:11:25 AM

Item ID: D3805-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly Aft, Low Gear
 Start Date: 21/11/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 04/01/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/21 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3805	B								

100 0.00

100

Large Fab

Large Fab

Memo

0.00

1-weld D3806-5 to D3805-5 together as per dwg D3805

304 S.S. Welding Rod

BATCH #: M118367

2-Transfer drill holes in bar

2059B → M120028

(10) MAL/12 12/01/11

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.00

QC 12.01.12 10x Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Quality Control

Memo

0.00

130 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00

130

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

140 QC3- Inspect Part Finish 0.00

140

QC

Quality Control

Memo

0.00

M118484

3=50
3200
4-20

10X2 M/L 12/01/12

10 x 12/01/13
counted measure

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

150

Small Fab

Small Fab

Memo

I- Bond D3807-5 gasket to inner surface of wearplate using a thin layer of 3m
 1300/1300L scotch grip adhesive as per dwg
 BATCH: 119597

De 12.01.15 (X10) Ø

160

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

8/26/16

(+10)

170

170

Packaging

Packaging

Identify as per dwg & Stock Location: FP-1

Memo

10X 12/01/16
 counted & measured

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/1/16 *[Signature]*
MLF
12-01-16

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NOTE: Date & initial all entries

Picklist Print

November-21-11 11:11:29 AM

Page 1

Work Order ID: 76785

76785

Parent Item: D3805-045

D3805-045

Parent Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 21/11/2011

Required Date: 04/01/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD IPP Rev:B 09-03-04 rev.a as per dwg DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-5		Manufactured	No			100	Each	52.0000	1	8			
D3805-5									**	(10) MAL/EZ		12/01/11	
Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				52					
					75676			46					
					75939			6					
D3806-5		Manufactured	No			100	Each	2.0000	1	8			
D3806-5									**	(10) MAL/EZ		12/01/11	
Bar													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA030				2					
					46781			2					
D3807-5		Manufactured	No			150	Each	6.0000	1	8			
D3807-5									**	B76742 (X10) Ae		12-01-15	
Gasket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				6					
					74944			6					

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NOTE: Date & initial all entries

8

7

6

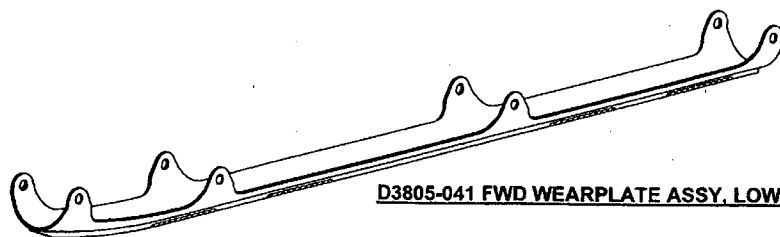
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4

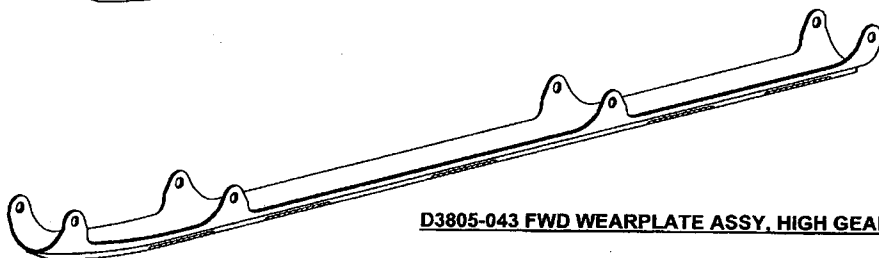
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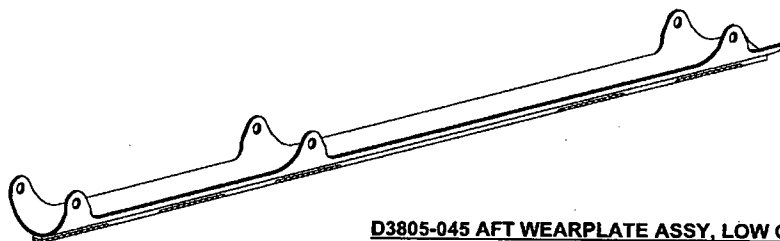
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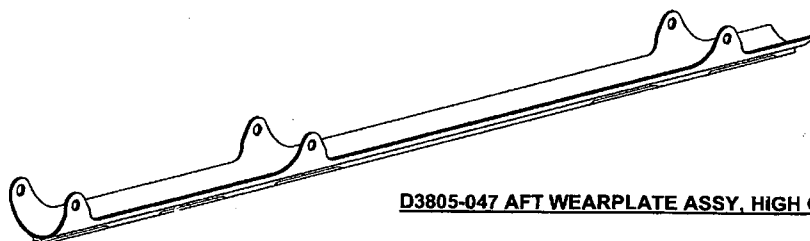
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOWN
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76785 H.L.J
11/11/21

RELEASED
2011-10-03
MB

REV. B	REVISED D3805-1F/-3F TO EASE MANUFACTURABILITY (ADDED CUTOFF AT TWO END OF PLATE PER PAR 11-108) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
REV. A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	11.09.16	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Dart Aerospace Ltd

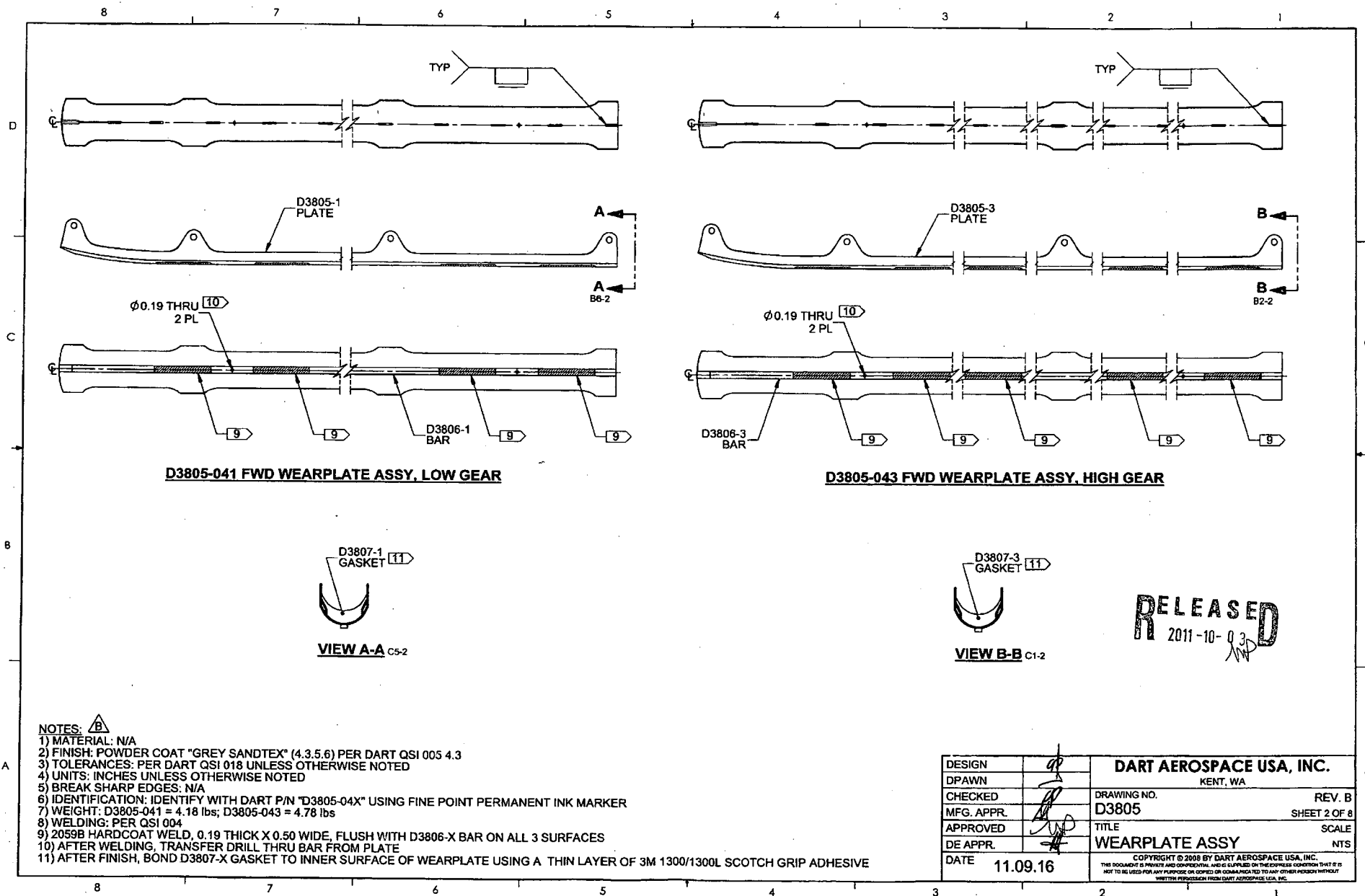
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

76785



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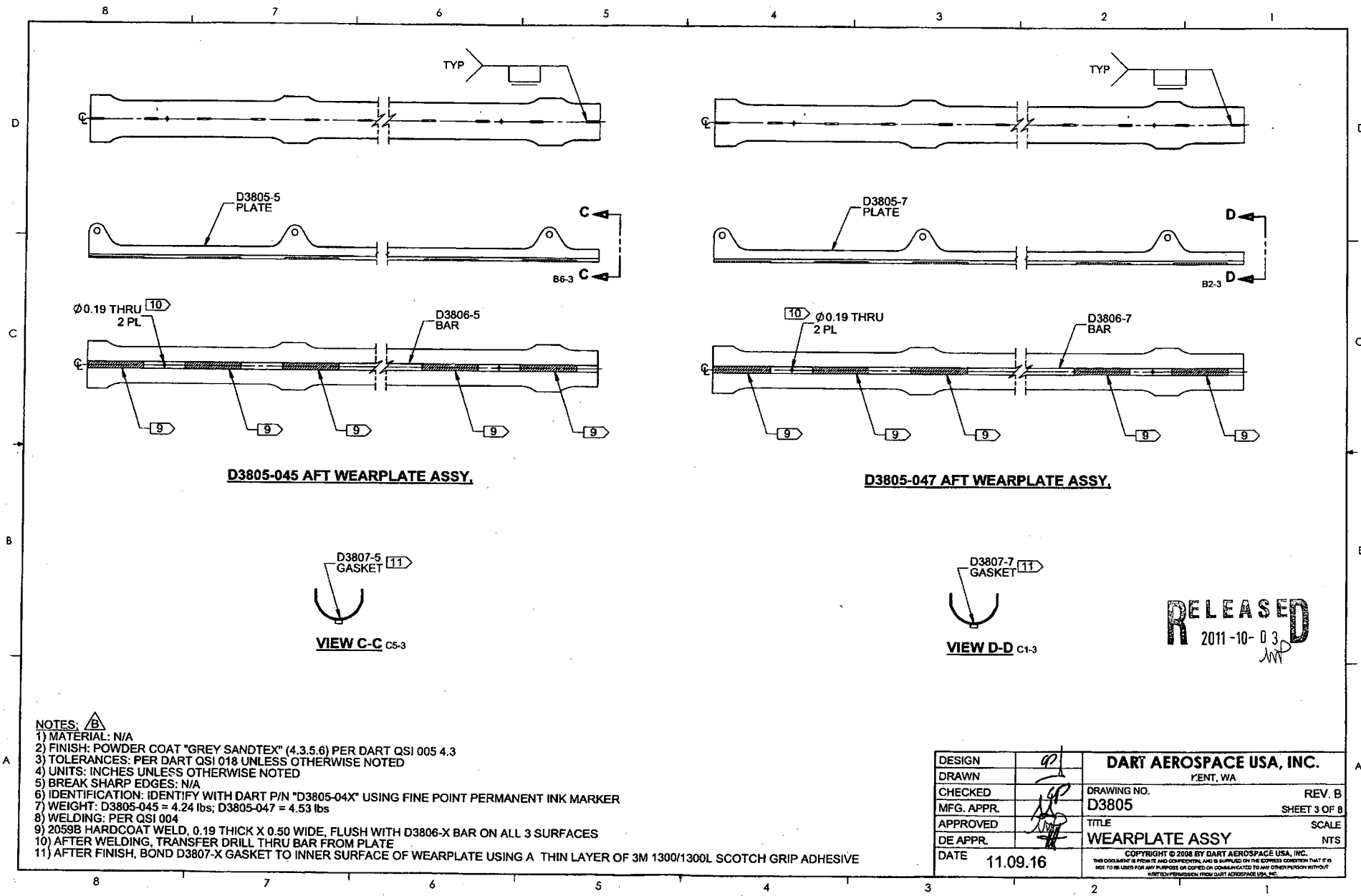
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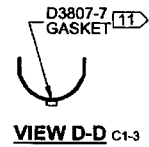
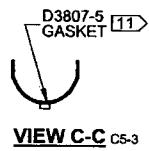
NOTE: Date & initial all entries

76785



D3805-045 AFT WEARPLATE ASSY.

D3805-047 AFT WEARPLATE ASSY.



RELEASED
2011-10-03
JMP

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		YENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	11.09.16	<small>COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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NOTE: Date & initial all entries

A horizontal number line with tick marks labeled 1 through 8 from right to left. The line is divided into segments by these tick marks.



C 42.073 C



1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)

RELEASED
2011-10-03

8 7 6 5 4 3 2 1

4 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

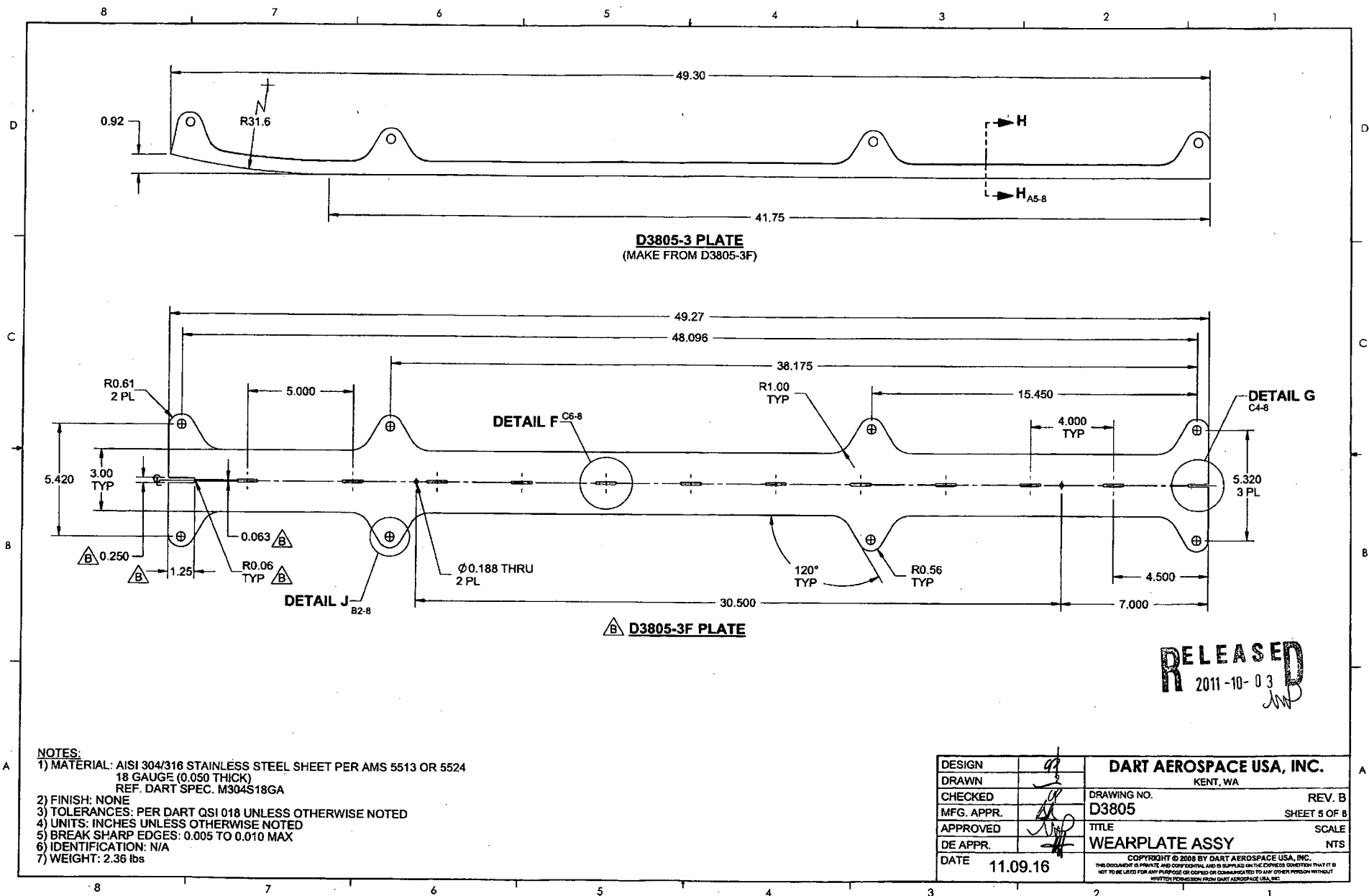
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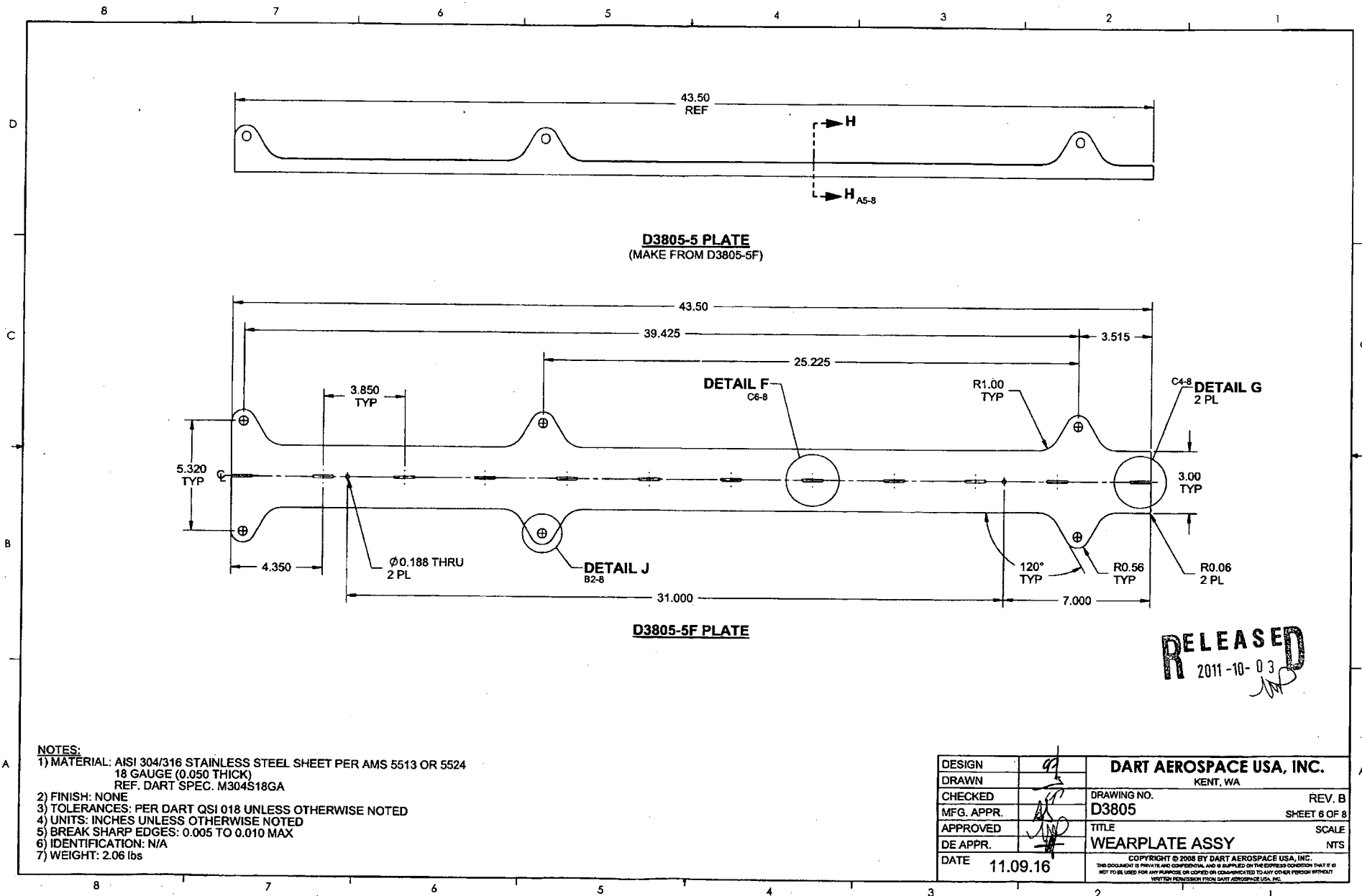
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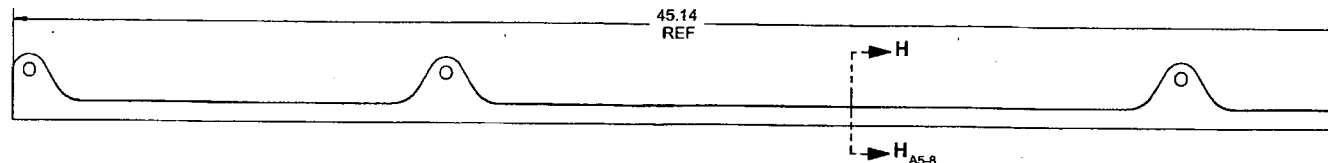
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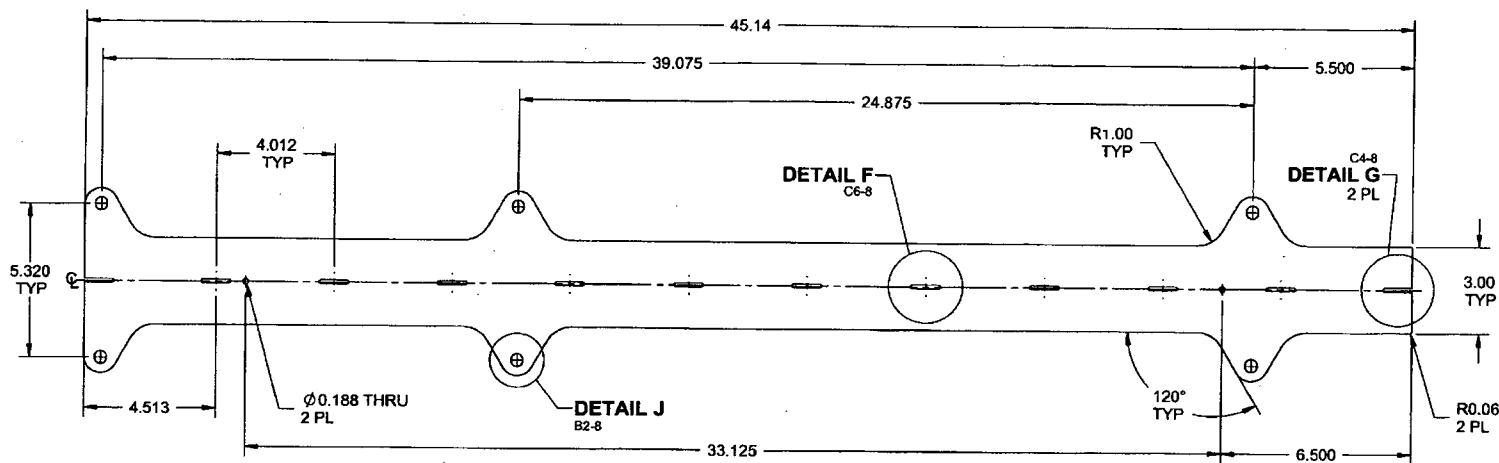
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NOTE: Date & initial all entries

76705



D3805-7 PLATE
(MAKE FROM D3805-7F)



D3805-7F PLATE

RELEASED
2011-10-03
ND

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 7 OF 8
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DE APPR.		WEARPLATE ASSY	NTS
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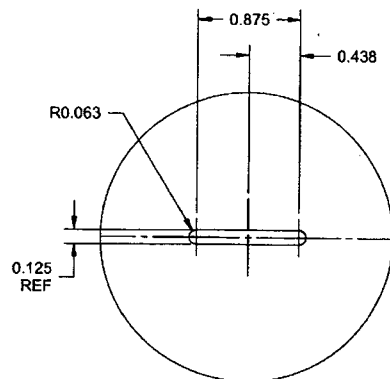
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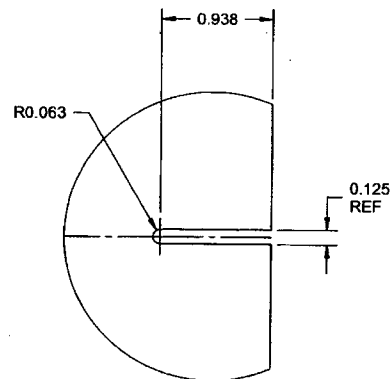
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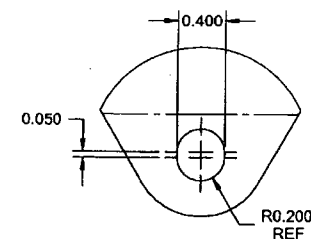
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



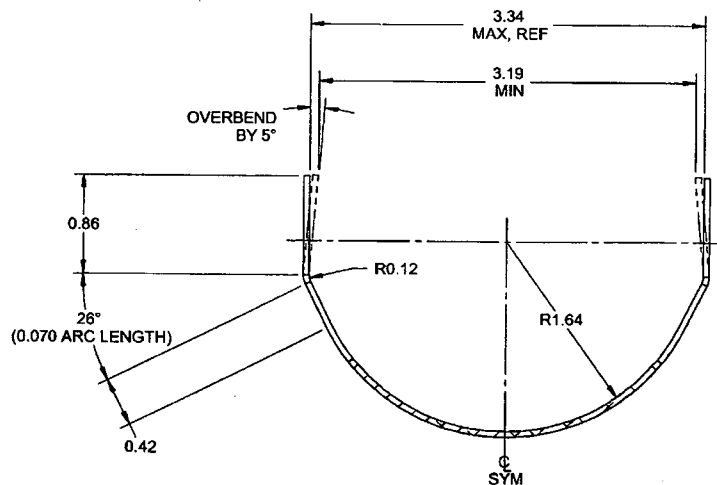
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

RELEASED
2011-10-03

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D3805	REV. B
MFG. APPR.		SHEET 8 OF 8	
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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